

Date: Friday, 2/23/2007 8:31:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ANGLE
Job Number	: 30871		Part Number	: D21751
Estimate Number	: 10196		Drawing Number	: D2175 REV E
P.O. Number	: N/A		Project Number	: N/A
This Issue	2/23/2007	S.O. No. : N/A	Drawing Revision	: E
Prsh Rev.	: NC		Material	: N/A
First Issue	: N/A		Due Date	: 3/24/2007
Previous Run	: 26495		Qty:	25
Written By			Um:	Each
Checked & Approved By				
Comment	: Est E 04.06.09 Reformat KJRF Est Rev:F 06-04-28 Manufactured on Water Jet JLM Est Rev:G As per Rev E 06-11-22 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 12.3953 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	Batch: <u>H162942</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2175 Dwg Rev: <u>E</u> Prog Rev: <u>E</u>	<u>m 07 03 01</u>
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>m 07 03 01</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	 <u>m 07/03/01</u>
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <u>m 07-03-05</u>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:01 AM
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Drawing Name: ANGLE

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Part Number: D21751

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SR 07/03/29

7.0 QC5 INSPECT WORK TO CURRENT STEP



20703-29



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

07-03-29 25

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB

07/03/29 28

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB

07/03/29 28

11.0 QC21 FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



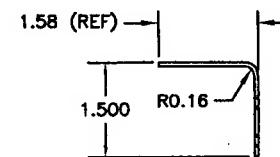
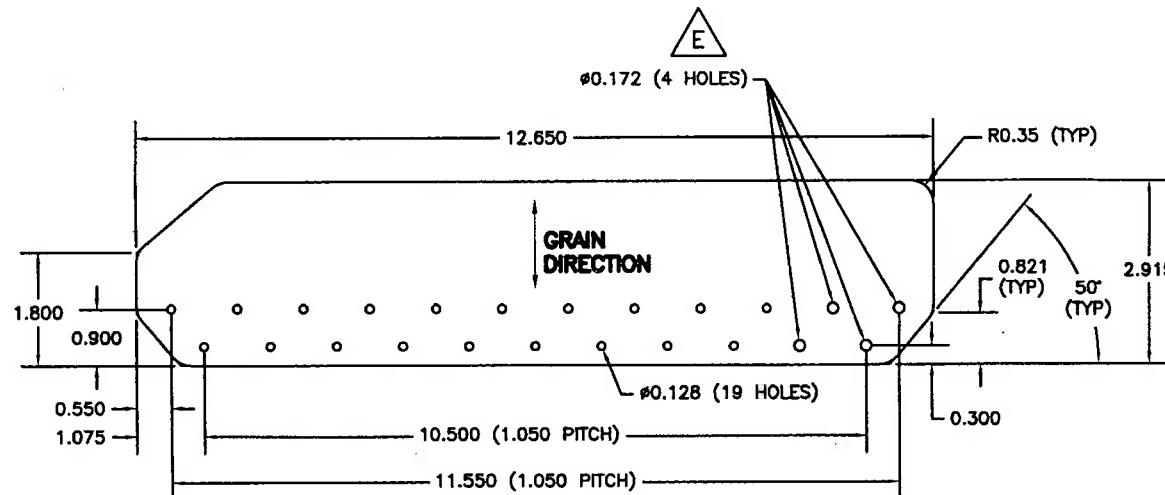
07/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF DART
NO. 20871

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2175	SHEET 1 OF 1
DATE 06.09.25		TITLE	SCALE 1:3
A 06.09.25	<i>MM</i>	NEW ISSUE	
B 06.09.25	<i>MM</i>	CHANGED DIMENSION	
C 06.09.25	<i>MM</i>	UPDATE FINISH SPEC	
D 04.06.03	<i>MM</i>	RE-DESIGN	
E 06.09.25	<i>MM</i>	INC HOLE DIA TO Ø0.172, 4 HOLES	

DART AEROSPACE LTD	Work Order:	30871
Description: Angle	Part Number:	D2175-11-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article **x** Prototype

Measured by:	M. M.
Date:	07.03.01

Audited by:	M
Date:	07/03/01

Prototype Approval:	<u>N/A</u>
Date:	<u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	